

Work Order ID 73099

Thursday, August 25, 2011 1:05:26 PM



Page 1

Item ID: D3443-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Tubing

Start Date: 8/25/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: mf

Date: 11-08-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3443

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1-Cut blank 5.97 " long 2-Debur

Handwritten signature 11/08/25 (10)

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1- Mill to length and drill holes (one side only) as per dwg D3443
2-Debur as per dwg D3443

Handwritten signature 11/08/29

10

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Handwritten signature 11/08/29

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73099

Thursday, August 25, 2011 1:05:27 PM

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Item ID: D3443-5

Accept

Revision ID:

Item Name: Tubing

Start Date: 8/25/2011 Start Qty: 10.00

Required Date: 9/5/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



QC

Quality Control

QC8- Inspect parts - second check

0.00

SL

11-08-29

①

Memo

0.00

140



Packaging

Packaging

Identify as per dwg & Stock Location: W/A Q15 0.00

0.00

Memo

*****STOCK IN LARGE FAB*****

0.00

EL 11-8-29 ⑩

150



QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

0.00

11/8/30 J

MF 11-08-30

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NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 1:05:20 PM

Page 1

Work Order ID: 73099



Parent Item: D3443-5



Parent Item Name: Tubing

Start Date: 8/25/2011

Required Date: 9/5/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: A05.11.14 New issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.120

Purchased

No

100

f

60.0000

0.495

5.210526



304 ss round tube .750 x .120w

Handwritten signature and date: 8/25/08/25

Location

Loc Qty

Loc Code

MAT017

60.00000027

114706 -

0.00000027

118390 -

60

Handwritten calculations:
2x 0.99
8x 3.96

W/O:		WORK ORDER CHANGES					
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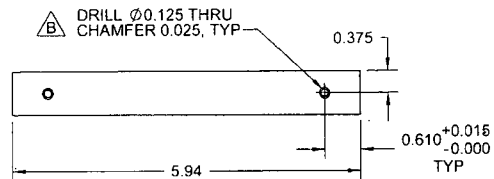
W/O:		WORK ORDER CHANGES					
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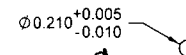
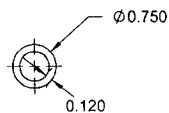
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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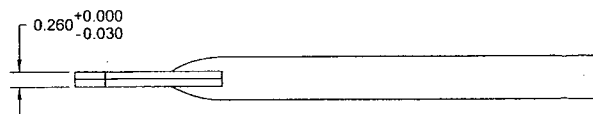
D3443-5 TUBING



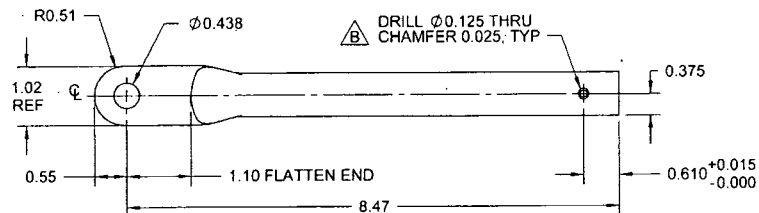
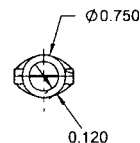
D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3443-7 TUBING



D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

RELEASED
01/08/25 MB

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3443	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STRUT WELDMENT ASSEMBLY NTS	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

562
547

W/O:		WORK ORDER CHANGES					
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